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D2344

Job Sheet 202280



Part No: D2344

Job Qty: 20 pcs

Part Name: Deck Plate Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/19

Job Tracking No:

Due Date: 11/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP Rev:D 00.06.26 Removed P/O for powder coat EC IPP Rev:E 07-07-04 Asper Rev F JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		11/18/19	0.11	3.23	Waterjet - Flow		DL 19/11/02
110	QC 2	20 pcs		11/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		DL 19/11/02
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

120 QC 8	20 pcs	11/18/19	0.00 0.00	QC 2 - 65	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - 2 - B4B	20 pcs	11/18/19	0.00 2.65	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
140 QC 5	20 pcs	11/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
QC 5 - 61					
QC 5 - 81					
150 Handfinish - 1-1 Chemical-	20	11/18/19	0.00 1.10	Handfinish - 1 - 1 -	

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B4B	pcs				B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	NOV 11 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
					155 QC 7	20 pcs
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	3 FEB 19-11-11

					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
160	Powdercoat - 4 Black Sand - B4B	20 pcs	11/18/19	0.00 0.72	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170	QC 3	20 pcs	11/18/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
180	Packaging 3-1 - Stock - B4B	20 pcs	11/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
190 QC 21 - SA	20 pcs	11/18/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	5-50
				QC 21 - SA - 53	

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Part Op 100 - 1-Cut as per dwg prog rev: F dwg rev: F
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - (QC8- Inspect parts - second check)
 130 - (Small Fab) 1-Deburr sharp edges 2-Countersink holes per Dwg D2344
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 155 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	14.9000 sf (.745 ea)	100-Waterjet - Flow - 1	5165803 3146235 5216341

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	15	175	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Litter Deck Plate Kit (350)	6.223Inches ± 0.010	6.233 6.213		6.225
2	Litter Deck Plate Kit (350)	5.598Inches ± 0.010	5.608 5.588		5.599
3	Litter Deck Plate Kit (350)	4.869Inches ± 0.010	4.879 4.859		4.871
4	Litter Deck Plate Kit (350)	3.889Inches ± 0.010	3.899 3.879		3.888
5	Litter Deck Plate Kit (350)	3.096Inches ± 0.010	3.106 3.086		3.099
6	Litter Deck Plate Kit (350)	2.891Inches ± 0.010	2.901 2.881		2.890
7	Litter Deck Plate Kit (350)	16.973Inches ± 0.010	16.983 16.963		16.973
8	Litter Deck Plate Kit (350)	0.450Inches ± 0.010	0.460 0.440		449
9	Litter Deck Plate Kit (350)	4.423Inches ± 0.010	4.433 4.413		4.425
10	Litter Deck Plate Kit (350)	4.723Inches ± 0.010	4.733 4.713		4.725
11	Litter Deck Plate Kit (350)	1.202Inches ± 0.010	1.212 1.192		1.200
12	Litter Deck Plate Kit (350)	5.869Inches ± 0.010	5.879 5.859		5.868
13	Litter Deck Plate Kit (350)	4.654Inches ± 0.010	4.664 4.644		4.655
14	Litter Deck Plate Kit (350)	0.656Inches + 0.005 - 0.000	0.661 0.656	Diameter	.656
15	Litter Deck Plate Kit (350)	1.888Inches ± 0.010	1.898 1.878		1.890
16	Litter Deck Plate Kit (350)	2.285Inches ± 0.010	2.295 2.275		2.284
17	Litter Deck Plate Kit (350)	2.683Inches ± 0.010	2.693 2.673		2.684
18	Litter Deck Plate Kit (350)	0.171Inches + 0.005 - 0.000	0.176 0.171	Diameter	0.170
19	Litter Deck Plate Kit (350)	3.491Inches ± 0.010	3.501 3.481		3.490
20	Litter Deck Plate Kit (350)	0.191Inches + 0.005 - 0.000	0.196 0.191	Diameter	0.190
21	Litter Deck Plate Kit (350)	3.123Inches ± 0.010	3.133 3.113		3.121
22	Litter Deck Plate Kit (350)	1.975Inches ± 0.010	1.985 1.965		1.97
23	Litter Deck Plate Kit (350)	0.128Inches + 0.005 - 0.001	0.133 0.127	Diameter	0.127

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				